**Work Order ID** 94107

*November-30-12 9:04:07 AM*

*94107*



**Item ID:** D3651-9

**Accept** *N900040100*

**Setup Start** *NS1*

**Stop** *NS2*

**Revision ID:**

**Item Name:** Inside Doubler

**Start Date:** 11/30/12 **Start Qty:** 4.00 *4*

**Required Date:** 12/14/12 **Req'd Qty:** 4.00 *4*

**Cust Item ID:**

**Customer:**

**Reference:**

**Run Start** *NR1*

**Stop** *NR2*

**Approvals:** **Process Plan:** MLJ **Date:** 12-12-03 **Tooling:** ________ **Date:** ________

**QC:** ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|

| Draw Nbr | Revision Nbr |
|---|---|
| D3651 | Rev B |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 100 *100* Waterjet FLOW CNC Waterjet 304 .018 | FLOW WATER JET **Memo** 1-Cut as per Dwg D3651 Dwg Rev: B Prog Rev: B 2-Deburr if necessary | 0.00 0.00 | | | | (4) | | | B 12-12-11 |
| 110 *110* QC Quality Control | QC2- Inspect parts off machine FAI/FAIB **Memo** | 0.00 0.00 | | | | (4) | | | B 12-12-11 |
| 120 *120* QC Quality Control | QC8- Inspect parts - second check **Memo** | 0.00 0.00 | 15 12 12 12 | | | 4 | | | |

DQA: ________ Date: ____________

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

| Work Order: ____________ | **DISPOSITION** | **AGAINST DEPARTMENT/PROCESS** | | | |
|---|---|---|---|---|---|
| Part No. ____________ | Rework ☐ | Skid-tube ☐ | Crosstube ☐ | Water Jet ☐ | Engineering ☐ |
| NCR No. ____________ | Scrap ☐ | Machining ☐ | Small Fab ☐ | Prod. Eng. Coor. ☐ | Quality ☐ |
| | Use-as-is ☐ | Thermoforming ☐ | Finishing ☐ | Rec/Store/Packaging ☐ | Other ☐ |
| | Work Order Update ☐ | Large Fab ☐ | Composite ☐ | Supplier ☐ | ☐ |

| **Root Cause** | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|
| Doc/Data ☐ | | | | | | | | | |
| Equip/Tooling ☐ | | | | | | | | | |
| Operator ☐ | | | | | | | | | |
| Material ☐ | | | | | | | | | |
| Setup ☐ | | | | | | | | | |
| Other ☐ | | | | | | | | | |
| Process ☐ | | | | | | | | | |
| Supplier ☐ | | | | | | | | | |
| Training ☐ | | | | | | | | | |
| Unapproved ☐ | | | | | | | | | |

## FAULT CATEGORY

| **Landing Gear** | **General** | | | |
|---|---|---|---|---|
| ☐ Bending | ☐ Bend | ☐ Grain | ☐ Ovalized | ☐ Pressure/Forced |
| ☐ Centre Not Concentric to O/S | ☐ BOM/Route | ☐ Hardware | ☐ Over/Under tolerance | ☐ Temperature/Cure |
| ☐ Cracks | ☐ Broken/Damaged | ☐ Inspection Incomplete | ☐ Part Incorrect | ☐ Weld |
| ☐ Crushed/Crimped | ☐ Burrs | ☐ Instructions Incomplete/Unclear | ☐ Part Lost/Missing | ☐ Wrong Stock Pulled |
| ☐ Cuffs | ☐ Contamination | ☐ Maintenance | ☐ Part Moved | |
| ☐ Heat Treat | ☐ Countersink | ☐ Mislabeled | ☐ Positioned Wrong | |
| ☐ Inspection Strip in Tube | ☐ Cut Too Short | ☐ Misread | ☐ Power Loss/Surge | ☐ Other ____ |
| ☐ Ripples in Bend | ☐ Drill Holes | ☐ Offset | ____________ | |
| ☐ Torque Waves in Extrusion | ☐ Drawing | ☐ Out of Calibration | ____________ | |
| ☐ Turning Sequence | ☐ Finish | ☐ Out of Sequence | ____________ | |
| ☐ Wave/Twist in Tube | ☐ Folio | ☐ Outside Dimensions | | |

**Work Order ID 94107** *94107*
*November-30-12 9:04:07 AM*



**Item ID:** D3651-9 **Accept** *N900040100* **Setup** **Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Inside Doubler

**Start Date:** 11/30/12 **Start Qty:** 4.00 *4* **Cust Item ID:**
**Required Date:** 12/14/12 **Req'd Qty:** 4.00 *4* **Customer:**
**Reference:**

**Run** **Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______
**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 *130* Packaging Packaging | Identify as per dwg & Stock Location: S188 | 0.00 | | | | 4X | | | SP 12-12-12 |
| | Memo | 0.00 | | | | | | | |
| 140 *140* QC Quality Control | QC21- Final Inspection - Work Order Release | 0.00 | | | | | MLJ | 12-12-12 | MLJ 12-12-12 |
| | Memo | 0.00 | | | | | | | |

DQA: ________ Date: ____________

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

| Work Order: ______ | **DISPOSITION** | **AGAINST DEPARTMENT/PROCESS** | | | |
|---|---|---|---|---|---|
| Part No. ______ | Rework ☐ | Skid-tube ☐ | Crosstube ☐ | Water Jet ☐ | Engineering ☐ |
| NCR No. ______ | Scrap ☐ | Machining ☐ | Small Fab ☐ | Prod. Eng. Coor. ☐ | Quality ☐ |
| | Use-as-is ☐ | Thermoforming ☐ | Finishing ☐ | Rec/Store/Packaging ☐ | Other ☐ |
| | Work Order Update ☐ | Large Fab ☐ | Composite ☐ | Supplier ☐ | ☐ |

| **Root Cause** | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|
| Doc/Data ☐ | | | | | | | | | |
| Equip/Tooling ☐ | | | | | | | | | |
| Operator ☐ | | | | | | | | | |
| Material ☐ | | | | | | | | | |
| Setup ☐ | | | | | | | | | |
| Other ☐ | | | | | | | | | |
| Process ☐ | | | | | | | | | |
| Supplier ☐ | | | | | | | | | |
| Training ☐ | | | | | | | | | |
| Unapproved ☐ | | | | | | | | | |

**FAULT CATEGORY**

| **Landing Gear** | **General** | | | |
|---|---|---|---|---|
| ☐ Bending | ☐ Bend | ☐ Grain | ☐ Ovalized | ☐ Pressure/Forced |
| ☐ Centre Not Concentric to O/S | ☐ BOM/Route | ☐ Hardware | ☐ Over/Under tolerance | ☐ Temperature/Cure |
| ☐ Cracks | ☐ Broken/Damaged | ☐ Inspection Incomplete | ☐ Part Incorrect | ☐ Weld |
| ☐ Crushed/Crimped | ☐ Burrs | ☐ Instructions Incomplete/Unclear | ☐ Part Lost/Missing | ☐ Wrong Stock Pulled |
| ☐ Cuffs | ☐ Contamination | ☐ Maintenance | ☐ Part Moved | |
| ☐ Heat Treat | ☐ Countersink | ☐ Mislabeled | ☐ Positioned Wrong | |
| ☐ Inspection Strip in Tube | ☐ Cut Too Short | ☐ Misread | ☐ Power Loss/Surge | ☐ Other ______ |
| ☐ Ripples in Bend | ☐ Drill Holes | ☐ Offset | ______ | |
| ☐ Torque Waves in Extrusion | ☐ Drawing | ☐ Out of Calibration | ______ | |
| ☐ Turning Sequence | ☐ Finish | ☐ Out of Sequence | ______ | |
| ☐ Wave/Twist in Tube | ☐ Folio | ☐ Outside Dimensions | | |

# Picklist Print

*November-30-12 9:04:06 AM*



**Work Order ID:** **94107**

**Parent Item:** **D3651-9**

**Parent Item Name:** Inside Doubler

**Start Date:** 11/30/12 **Required Date:** 12/14/12

**Start Qty:** 4.00 **Required Qty:** 4.00

**Comments:**

IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| M304S26GA<br>304/316 0.018 SHEET | | Purchased | No | | | 110 | sf | 378.9700 | **0.431** | **1.8147368** | 2 | B12-12-11 | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| MAT020 | 378.97 | | |
| 117798 | 35.06 | | |
| 122753 | 87.91 | | 122753 |
| 123135 | 256 | | |

(4)

DQA: ________ Date: ____________

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

| Work Order: ____________ | DISPOSITION | AGAINST DEPARTMENT/PROCESS | | | |
|---|---|---|---|---|---|
| Part No. ____________ | Rework ☐ | Skid-tube ☐ | Crosstube ☐ | Water Jet ☐ | Engineering ☐ |
| NCR No. ____________ | Scrap ☐ | Machining ☐ | Small Fab ☐ | Prod. Eng. Coor. ☐ | Quality ☐ |
| | Use-as-is ☐ | Thermoforming ☐ | Finishing ☐ | Rec/Store/Packaging ☐ | Other ☐ |
| | Work Order Update ☐ | Large Fab ☐ | Composite ☐ | Supplier ☐ | ☐ |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|
| Doc/Data ☐ | | | | | | | | | |
| Equip/Tooling ☐ | | | | | | | | | |
| Operator ☐ | | | | | | | | | |
| Material ☐ | | | | | | | | | |
| Setup ☐ | | | | | | | | | |
| Other ☐ | | | | | | | | | |
| Process ☐ | | | | | | | | | |
| Supplier ☐ | | | | | | | | | |
| Training ☐ | | | | | | | | | |
| Unapproved ☐ | | | | | | | | | |

**FAULT CATEGORY**

| Landing Gear | General | | | |
|---|---|---|---|---|
| ☐ Bending | ☐ Bend | ☐ Grain | ☐ Ovalized | ☐ Pressure/Forced |
| ☐ Centre Not Concentric to O/S | ☐ BOM/Route | ☐ Hardware | ☐ Over/Under tolerance | ☐ Temperature/Cure |
| ☐ Cracks | ☐ Broken/Damaged | ☐ Inspection Incomplete | ☐ Part Incorrect | ☐ Weld |
| ☐ Crushed/Crimped | ☐ Burrs | ☐ Instructions Incomplete/Unclear | ☐ Part Lost/Missing | ☐ Wrong Stock Pulled |
| ☐ Cuffs | ☐ Contamination | ☐ Maintenance | ☐ Part Moved | |
| ☐ Heat Treat | ☐ Countersink | ☐ Mislabeled | ☐ Positioned Wrong | |
| ☐ Inspection Strip in Tube | ☐ Cut Too Short | ☐ Misread | ☐ Power Loss/Surge | ☐ Other |
| ☐ Ripples in Bend | ☐ Drill Holes | ☐ Offset | | |
| ☐ Torque Waves in Extrusion | ☐ Drawing | ☐ Out of Calibration | | |
| ☐ Turning Sequence | ☐ Finish | ☐ Out of Sequence | | |
| ☐ Wave/Twist in Tube | ☐ Folio | ☐ Outside Dimensions | | |

| DART AEROSPACE LTD | Work Order: | 94107 |
|---|---|---|
| | | |
| **Description:** Inside Doubler | **Part Number:** | **D3651-9** |
| | | |
| **Inspection Dwg:** D3651 **Rev:** B | | **Page 1 of 1** |

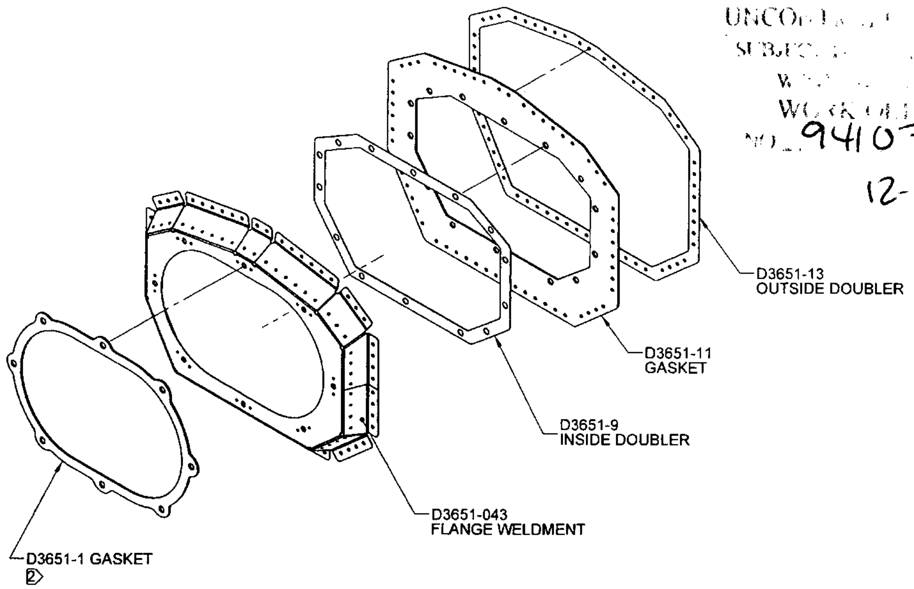
## FIRST ARTICLE INSPECTION CHECKLIST

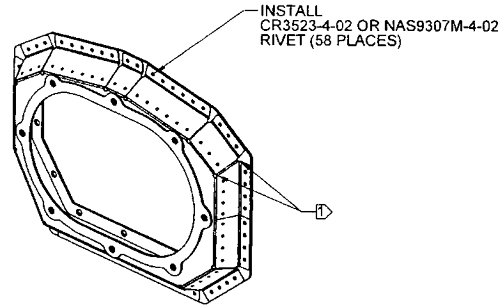
[X] **First Article** [ ] **Prototype**

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| Ø0.25 | +0.004/-0.001 | .252 | 2 | | V [illegible] | |
| 0.250 | +/-0.010 | .251 | 2 | | V | |
| 0.500 | +/-0.010 | .508 | 2 | | V | |
| 6.33 | +/-0.030 | 6.337 | 2 | | V | |
| 9.81 | +/-0.030 | 9.810 | 2 | | PROW302 | |
| 2.818 | +/-0.010 | 2.814 | [illegible] | | V | |
| 2.100 | +/-0.010 | 2.101 | 2 | | V | |
| 2.100 | +/-0.010 | 2.103 | 2 | | V | |
| 2.575 | +/-0.010 | 2.576 | 2 | | V | |
| 2.000 | +/-0.010 | 1.998 | 2 | | V | |
| 5.514 | +/-0.010 | 5.513 | 2 | | V | |
| 2.750 | +/-0.010 | 2.747 | 2 | | V | |
| 2.200 | +/-0.010 | 2.203 | 2 | | V | |
| 2.371 | +/-0.010 | 2.373 | 2 | | V | |
| 1.325 | +/-0.010 | 1.318 | 2 | | V | |
| 3.112 | +/-0.010 | 3.117 | 2 | | V | |
| 1.400 | +/-0.010 | 1.400 | 2 | | V | |
| 5.514 | +/-0.010 | 5.519 | 2 | | V | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| Measured by: | [illegible] | Audited by: | 15 | Prototype Approval: | N/A |
|---|---|---|---|---|---|
| Date: | 12-12-11 | Date: | 12-12-12 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | 08.04.17 | New Issue | KJ/DD [illegible] | [illegible] |




UNCONTROLLED COPY
WORK ORDER
NO. 94107MLJ
12-12-03

PART LIST

| QTY -041 | PART NUMBER | DESCRIPTION |
|---|---|---|
| X | D3651-041 | AFT BASE ASSEMBLY |
| | | |
| 1 | D3651-043 | FLANGE WELDMENT |
| 1 | D3651-1 | GASKET |
| 1 | D3651-9 | INSIDE DOUBLER |
| 1 | D3651-11 | GASKET |
| 1 | D3651-13 | OUTSIDE DOUBLER |
| 58 | CR3523-4-02 or NAS9307M-4-02 | RIVET |

RELEASED 08-03-27

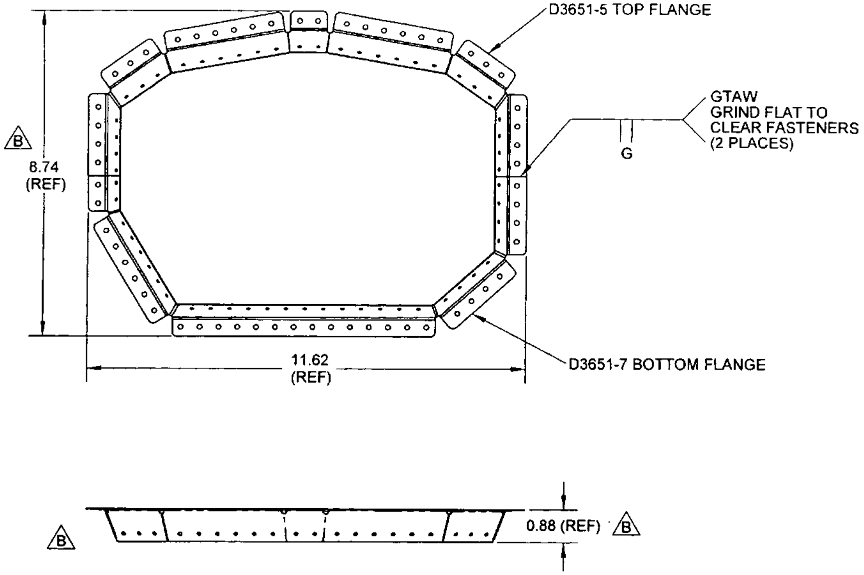
## D3651-041 AFT BASE ASSEMBLY

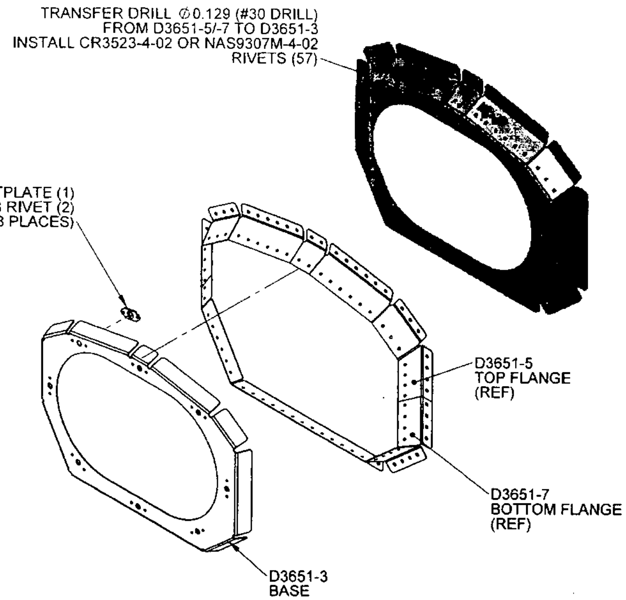
D3651-041 NOTES:
1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.6 lbs

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| B | SHEET 1: GENERAL UPDATE<br>SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE<br>SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE<br>SHEET 7: 5.514 WAS 5.504 | RF | 08.01.07 |
| A | NEW ISSUE | RF | 07.11.07 |

| | | |
|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD**<br>HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | | DRAWING NO. D3651 — REV. B — SHEET 1 OF 9 |
| MFG. APPR. | | |
| APPROVED | | TITLE AFT BASE ASSEMBLY — SCALE 1:4 |
| DE APPR. | | |
| DATE | 08.01.07 | |

94107




| QTY -043 | PART NUMBER | DESCRIPTION |
|---|---|---|
| X | D3651-043 | FLANGE WELDMENT |
| | | |
| 1 | D3651-3 | BASE |
| 1 | D3651-5 | TOP FLANGE |
| 1 | D3651-7 | BOTTOM FLANGE |
| 16 | MS20427M3-3 | RIVET |
| 8 | MS21060-3K | NUTPLATE |
| 57 | CR3523-4-02 or NA9307M-4-02 | RIVET |

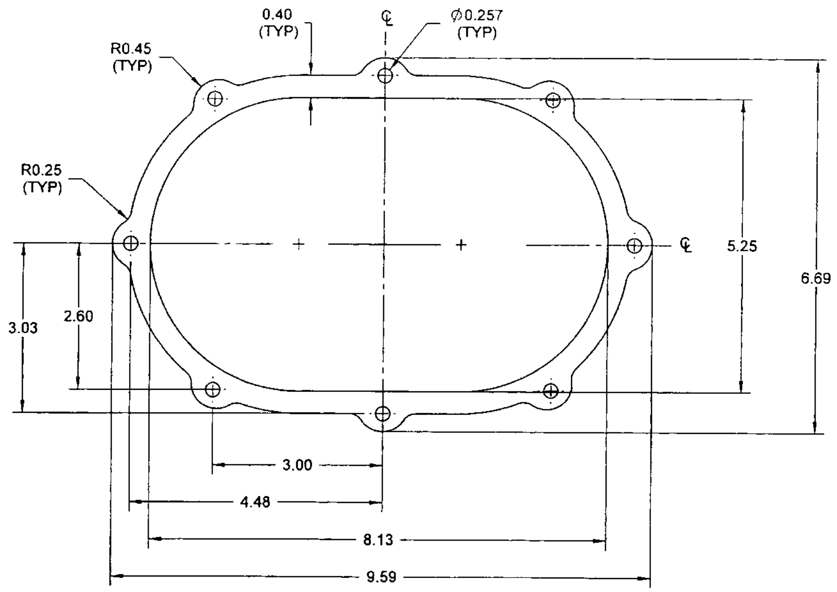
RELEASED 08.03.27

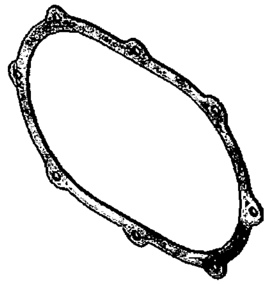
**D3651-043 FLANGE WELDMENT**

D3651-043 NOTES:
1) WELD PER QSI 004
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.76 lbs

| DESIGN | RF | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| DRAWN | RF | DRAWING NO. D3651 REV. B SHEET 2 OF 9 |
| CHECKED | | |
| MFG. APPR. | | |
| APPROVED | | TITLE AFT BASE ASSEMBLY SCALE 1:3 |
| DE APPR. | | |
| DATE | 08.01.07 | |

9Y107



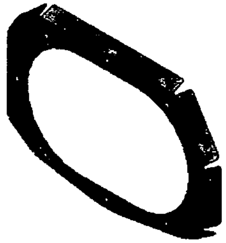



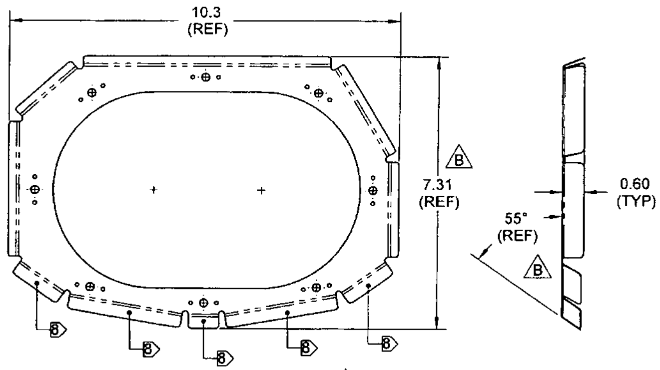
**D3651-1 GASKET**

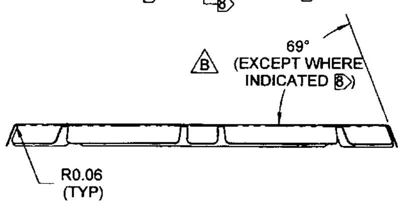
NOTES:
1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) PART IS SYMMETRIC ABOUT ℄
8) WEIGHT: 0.09 lbs

08.03.27

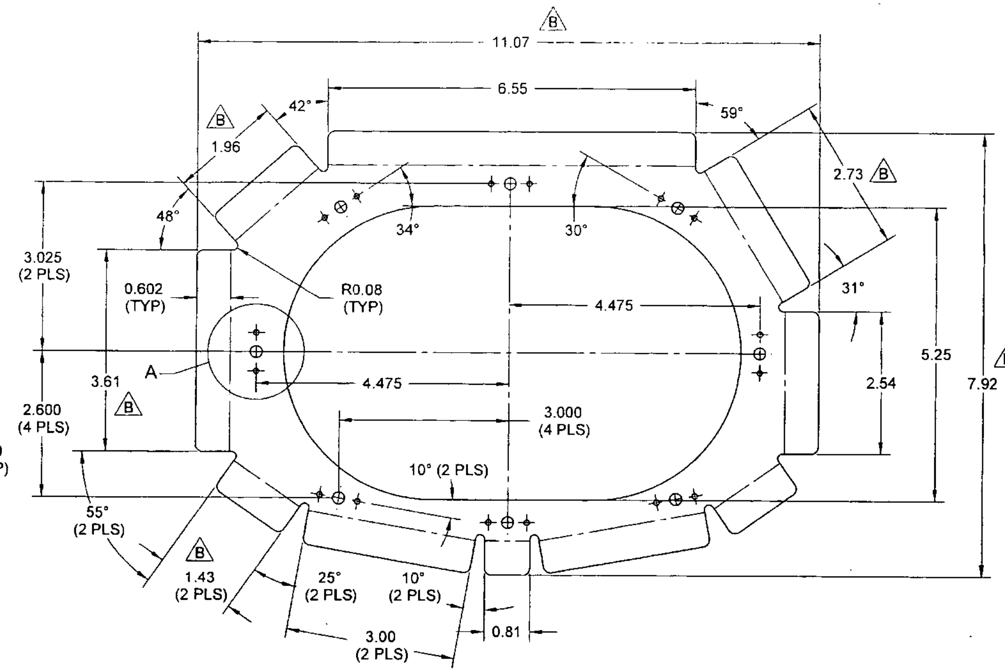
| DESIGN | RF | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| DRAWN | RF | |
| CHECKED | | DRAWING NO. D3651 — REV. B — SHEET 3 OF 9 |
| MFG. APPR. | | |
| APPROVED | | TITLE: AFT BASE ASSEMBLY — SCALE 1:2 |
| DE APPR. | | |
| DATE | 08.01.07 | |



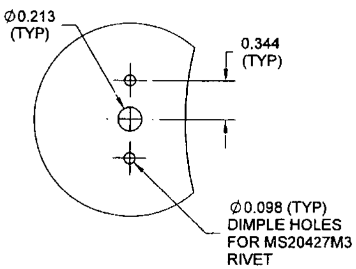



**D3651-3 BASE**
**(MAKE FROM D3651-3F FLAT PATTERN)**




**D3651-3F FLAT PATTERN**



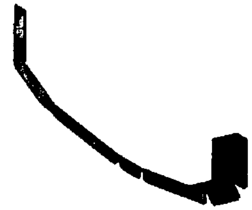

**DETAIL A**

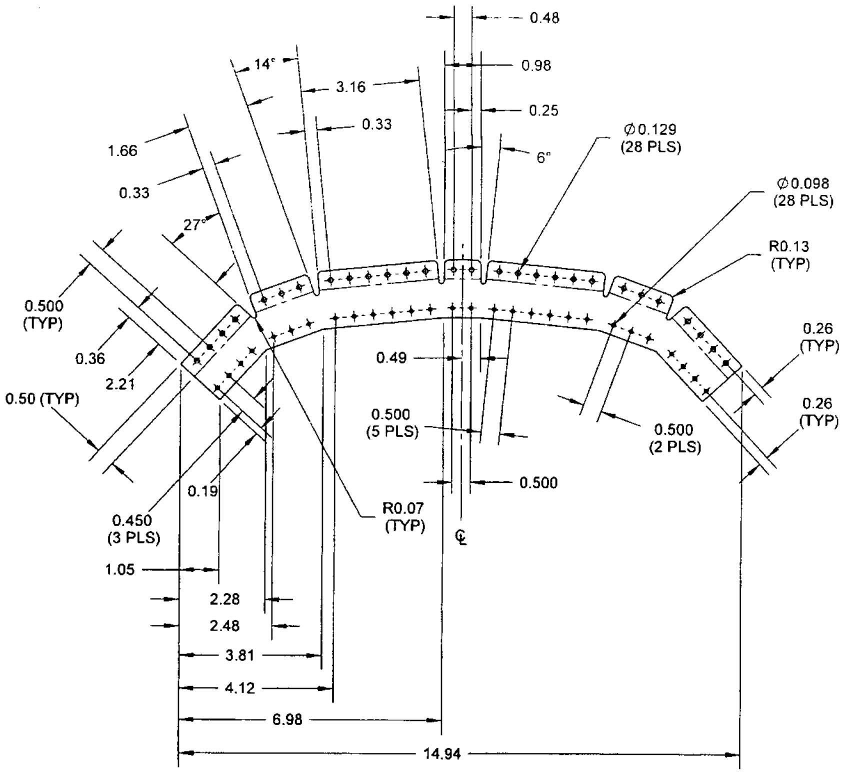
NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.27 lbs
8) BEND TO 55° WHERE INDICATED

08.03.27

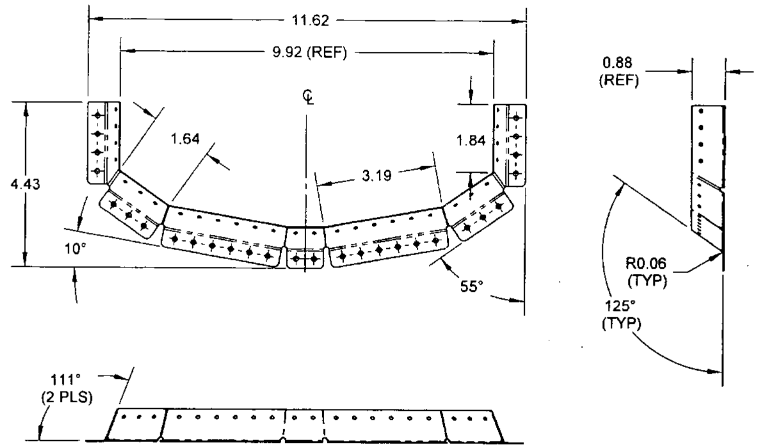
| DESIGN | RF | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| DRAWN | RF | |
| CHECKED | | DRAWING NO. D3651 — REV. B — SHEET 4 OF 9 |
| MFG. APPR. | | |
| APPROVED | | TITLE: AFT BASE ASSEMBLY — SCALE 1:2 |
| DE APPR. | | |
| DATE | 08.01.07 | |

94107






**D3651-5F FLAT PATTERN** B



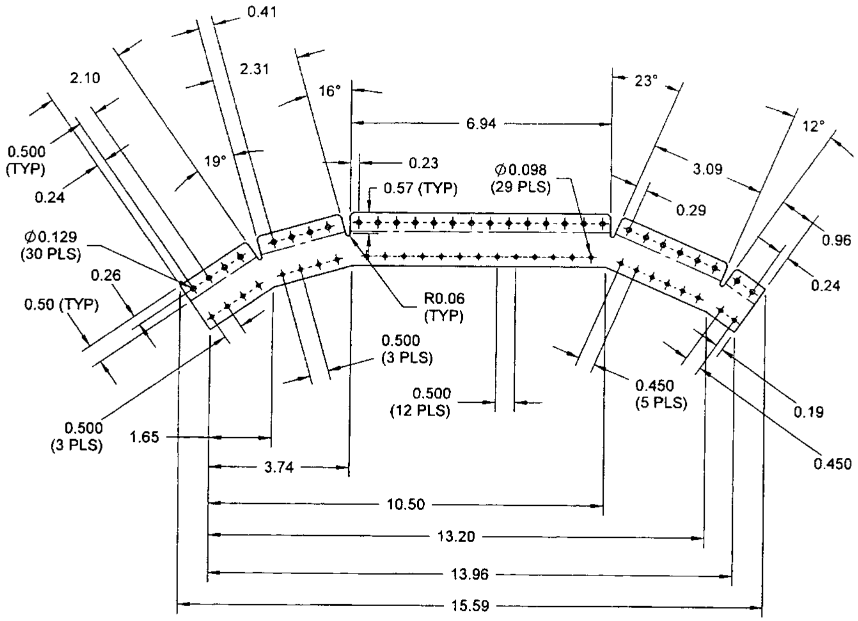

**D3651-5 TOP FLANGE BEND DETAIL** B
**(MAKE FROM D3651-5F FLAT PATTERN)**

08-03-27 MP

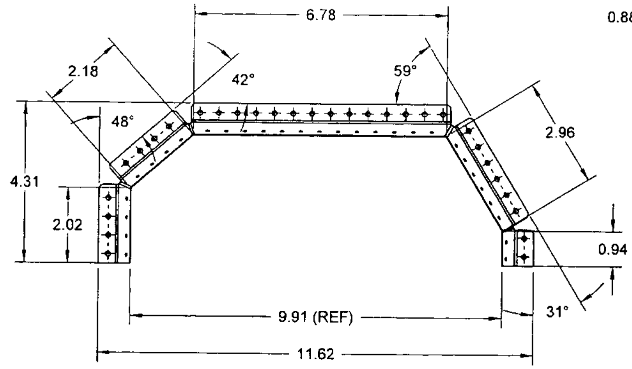
NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019
(REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.02 lbs

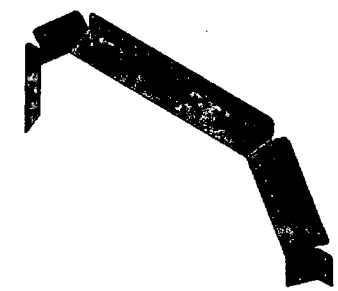
| DESIGN | RF | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| DRAWN | RF | |
| CHECKED | [signature] | DRAWING NO. D3651 — REV. B — SHEET 5 OF 9 |
| MFG. APPR. | [signature] | |
| APPROVED | [signature] | TITLE: AFT BASE ASSEMBLY — SCALE 1:3 |
| DE APPR. | [signature] | |
| DATE | 08.01.07 | |

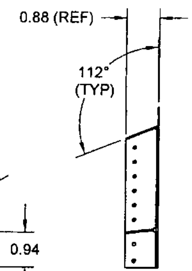
94107




**D3651-7F FLAT PATTERN** B



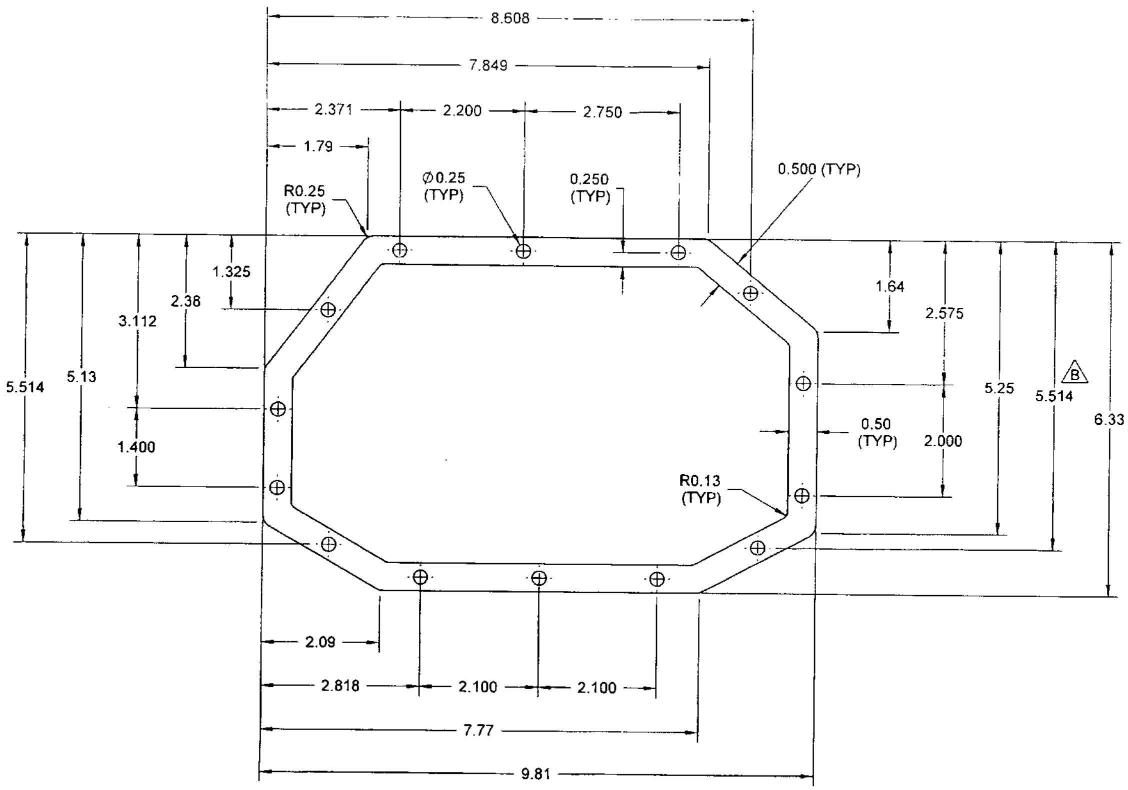


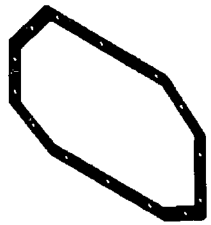

**D3651-7 BOTTOM FLANGE BEND DETAIL** B
**(MAKE FROM D3651-7F FLAT PATTERN)**

08-03-27

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019
(REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.02 lbs

| | | |
|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | [signature] | DRAWING NO. D3651 REV. B SHEET 6 OF 9 |
| MFG. APPR. | [signature] | |
| APPROVED | [signature] | TITLE AFT BASE ASSEMBLY SCALE 1:3 |
| DE APPR. | [signature] | |
| DATE | 08.01.07 | |



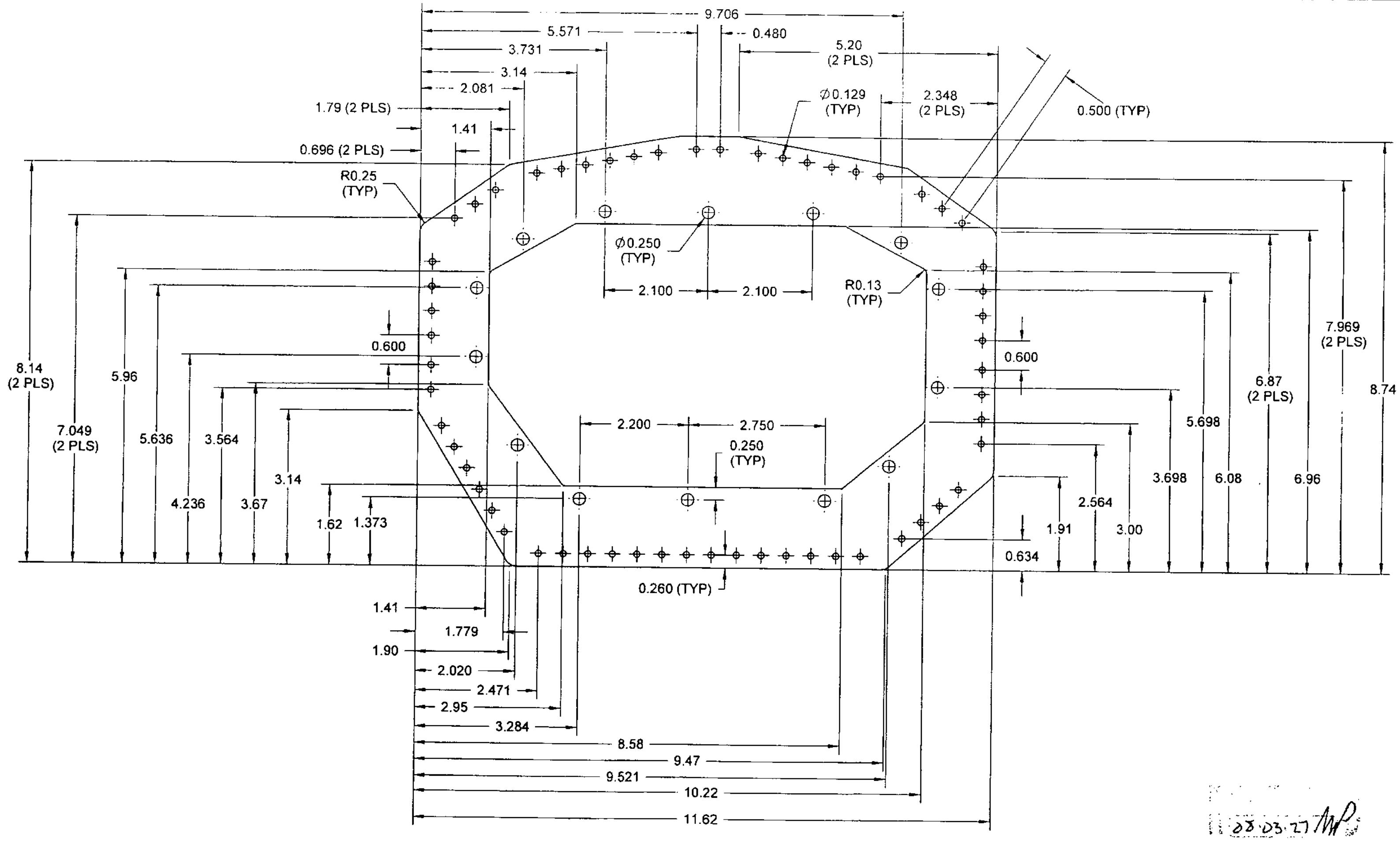



**D3651-9 INSIDE DOUBLER**

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.07 lbs

| DESIGN | RF | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| DRAWN | RF | DRAWING NO. D3651 — REV. B — SHEET 7 OF 9 |
| CHECKED | | |
| MFG. APPR. | | TITLE: AFT BASE ASSEMBLY — SCALE 1:2 |
| APPROVED | | |
| DE APPR. | | |
| DATE | 08.01.07 | |

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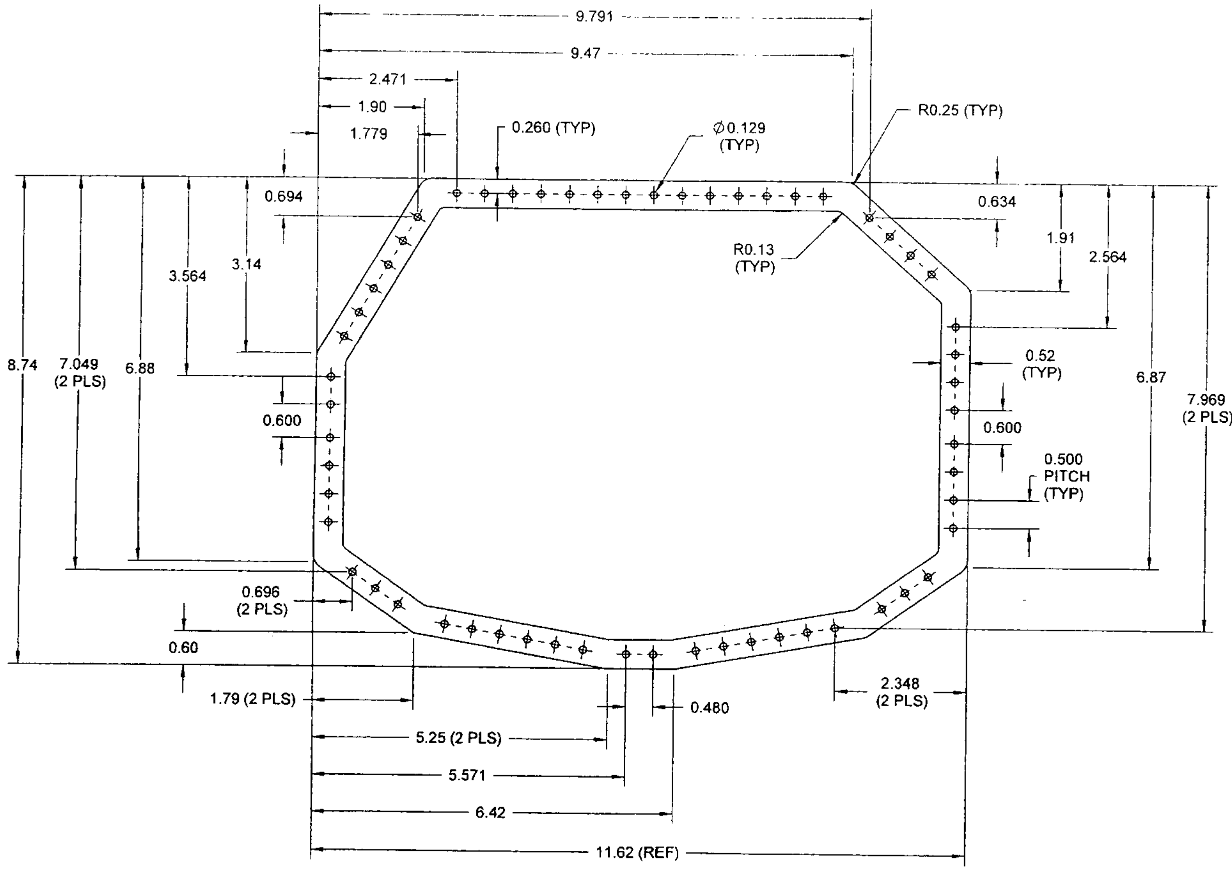

08.03.27

NOTES:
1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.2 lb

**D3651-11 GASKET** (B)

| | | |
|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | | DRAWING NO. D3651 — REV. B — SHEET 8 OF 9 |
| MFG. APPR. | | |
| APPROVED | | TITLE: AFT BASE ASSEMBLY — SCALE 1:2 |
| DE APPR. | | |
| DATE | 08.01.07 | |

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**D3651-13 OUTSIDE DOUBLER** B

08.03.27

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.10 lbs

| | | |
|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | | DRAWING NO. D3651 — REV. B — SHEET 9 OF 9 |
| MFG. APPR. | | |
| APPROVED | | TITLE AFT BASE ASSEMBLY — SCALE 1:2 |
| DE APPR. | | |
| DATE | 08.01.07 | |